

Work Order ID ~~76274~~***76274***

Page 1

Tuesday, November 08, 2011 1:28:32 PM

Item ID: D3640-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Belt Guide

Start Date: 11/8/2011

Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/22/2011

Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: M.L.JDate: 11/11/08 Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3640

Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.700 " long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1 Punch.
HAAS CNC vertical machine #1

Memo

0.00

1-Mill as per Folio FA670 & Dwg D3640 Rev: ____ 2-Deburr and Blend
rad intersection with deburring tool.

issue P/O to Archer. P/O: 15679

machine as per drawing D 3640 REV. A

120

0.00

120

QC2-Inspect parts off machine FA1/FA1B

QC

Memo

0.00

Quality Control

rec'd + inspect for transit damage.
attached COC to WIO

11/13/2011 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76274

76274

Page 2

Tuesday, November 08, 2011 1:28:32 PM

Item ID: D3640-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Belt Guide
 Start Date: 11/8/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>72</u>			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>SI 244</u> Memo	0.00 0.00				<u>72</u>	<u>Sp 12-03-07</u>		
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					<u>MLJ 12/03/07</u>		

MLJ 12/03/07
7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, November 08, 2011 1:28:36 PM

Work Order ID: 76274

76274

Parent Item: D3640-1

D3640-1

Parent Item Name: Belt Guide

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDEL RINB0.75X1-250

Purchased

No

100

f

31.9328

0.4

2.526316

MDFI RINB0 75X1 250

Delrin Bar

Location

Loc Qty

Loc Code

MAT055

31.9328

117985

0.5328

118066

7

119133

24

14535

0.4

3.2 ~~4~~ 4/12/13

D 3640-1P

X 10

11/23/2 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

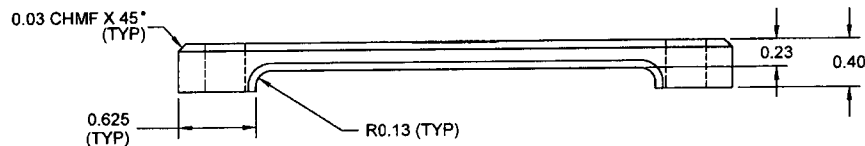
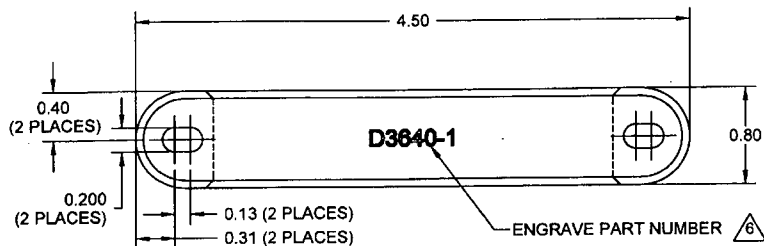
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

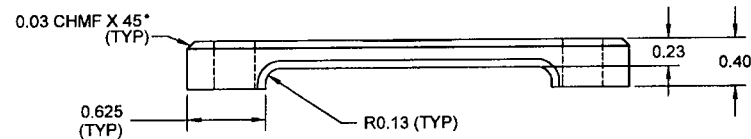
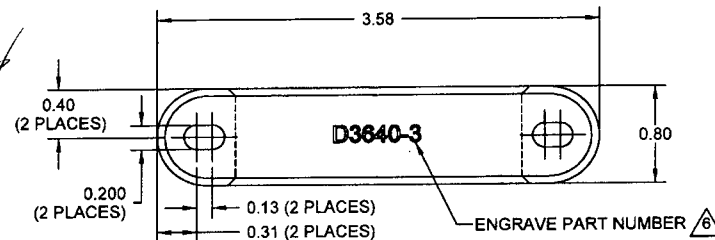
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
 REF. 100
 ENGINEER
 UNCONTROLLED COPY
 SUBJECT TO APPROVAL
 WITHOUT NOTICE
 WORK ORDER
 NO. 76279
 10/11-11-08



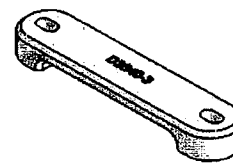
D3640-1 BELT GUIDE
 (WAS GENEVA P/N G10605-1)



D3640-3 BELT GUIDE
 (WAS GENEVA P/N G10605-2)

RELEASED
 07.09.07

- NOTES:
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL BAR (REF DART SPEC M-DELRIN-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBERS TO MAX DEPTH OF 0.010 AT LOCATIONS SHOWN
 - 7) WEIGHT: 0.03 lbs



A	NEW ISSUE; REPLACES G10605	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.27		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3640	REV. A
TITLE BELT GUIDE	SHEET 1 OF 1
SCALE 1:1	

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 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries




1393 Major Road
Orleans, Ontario
K1E 1H3

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

 Po Number	Part Number	Quantities
15679	D3200-3P	20
	D3640-1P <i>S. 17/03/16</i>	7

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15679 issued by Dart Aerospace Inc.

A handwritten signature in black ink, appearing to read "Alex Mazerolle", is written over a horizontal line.

Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3



Inspection Report

Customer Name Dart Aerospace	QTY 20	DWG # D3200-3	REV.	Part Name Door Wedge	Date Feb 29/2012	Lot#	Job # 477-5
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Page 1 of ____	Inspection Interval	Special Notes
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Item #	DWG. Dim	Tolerance	Operator First Off	QA First Off		QA Final		4	8	12	16	20
				A	R	A	R					
	Rev			✓		✓						
	MAT	supplied	UHMV	✓		✓						
	SUB	no		✓		✓						
	Deburr	.005/.010		✓		✓						
1	.500	+/- .005	.500	✓		✓						
2	1.722	+/- .005	1.723	✓		✓		1.723	1.722	1.721	1.721	1.721
3	.380	+/- .005	.381	✓		✓						
4	.975	+/- .005	P.P.	✓		✓						
5	R.13	+/- .010	.125	✓		✓						
6	2X		✓	✓		✓						
7	Engraving		OK	✓		✓		✓	✓	✓	✓	✓
8	Ø.196	+/- .005	.195	✓		✓		.195	.195	.195	.195	.195
9	Ø.405	+/- .005	.407	✓		✓		.407	.407	.407	.407	.407
10	100°		100°	✓		✓						
11	2X		✓	✓		✓						
12	R.114	+/- .005	P.P.	✓		✓						
13	.015	+/- .005	.0107	✓		✓						
14	.050	+/- .005	.0407	✓		✓						
15	45°		✓	✓		✓						
16	.75	+/- .010	.7495	✓		✓		.749	.749	.749	.749	.749



Inspection Report

Customer Name Dart Aerospace	QTY 7	DWG # D3640-1	REV A	Part Name Belt Guide	Date Feb 29/2012	Lot#	Job # 477-8
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Page 1 of ____		Inspection Interval		Special Notes											
Item #	DWG. Dim	Tolerance	Operator	QA First Off		QA Final		2	3	4	5	6	7		
	Rev		A	First Off	A	R	A	R							
	MAT	supplied	Delrin	✓	✓		✓								
	SUB	no		✓	✓		✓								
	Deburr	.005/.010	✓	✓	✓		✓								
1	4.50	+/- .010	4.500	✓	✓		✓		4.498	4.498	4.498	4.500	4.500	4.500	
2	.40	+/- .010	.40	✓	✓		✓								
3	2X		✓	✓	✓		✓								
4	.200	+/- .005	.201	✓	✓		✓		.201	.201	.201	.201	.201	.201	
5	2X		✓	✓	✓		✓								
6	.31	+/- .010	.310	✓	✓		✓								
7	2X		✓	✓	✓		✓								
8	.13	+/- .010	.130	✓	✓		✓								
9	2X		✓	✓	✓		✓								
10	Engraving		OK	✓	✓		✓		✓	✓	✓	✓	✓	✓	
11	.80	+/- .010	.7995	✓	✓		✓		.7995	.7995	.7995	.7995	.7995	.7995	
12	.23	+/- .010	.230	✓	✓		✓		.230	.230	.230	.230	.230	.230	
13	.40	+/- .010	.400	✓	✓		✓		.400	.400	.400	.400	.400	.400	
14	R.13	+/- .010	.125	✓	✓		✓								
15	.625	+/- .005	.623	✓	✓		✓		.623	.623	.623	.623	.623	.623	
16	.03	+/- .010	.030	✓	✓		✓								
17	45°		✓	✓	✓		✓								

Date of Issue July, 13, 2005.



1393 Major Road
Orleans, ON
K1E 1H3

Phone # 613-899-2405

Packing Slip

Date	Invoice #
2/29/2012	65

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	2/29/2012	FedEx	Archer	

Qty	Item Code	Description
20 7	Sales Sales	D3200-3P item 5 on PO# 15679 D3640-1P item 8 on PO# 15679 HST (ON) on sales